

Date: Wednesday, 04/02/2009 6:50:14 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D3691-1 - NDT/LPI
Job Number : 45485	
Estimate Number : 10804	
P.O. Number :	Part Number : D36911
This Issue : 04/02/2009 S.O. No. :	Drawing Number : REWORK - LPI
Prsht Rev. : NC	Project Number :
First Issue : / / Type : MACHINED PARTS	Drawing Revision :
Previous Run : 00015	Material :
Written By : <u>W</u>	Due Date : 11/02/2009 Qty: <u>24</u> Um: Each
Checked & Approved By : <u>W</u>	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	QC5	INSPECT WORK TO CURRENT STEP



Comment: PULL FROM STOCK:

24 X D3691-1 B44826

HAVE PARTS BROUGHT TO NDT BOOTH
 FOR LPI PER ASTM1417, LEVEL 2
 PER QSI038

Sorloz/04

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

ISSUE P.O. 8149
 ACUREN, LPI PER ASTM1417, LEVEL 2
 PER QSI038

C 209/02/05

24

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

RECEIVE AND INSPECT
 ENSURE C OF C ATTACHED

P 24/5 24

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

S 09/02/05 24 counter

Date: Wednesday, 04/02/2009 6:50:14 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D3691-1 - NDT/LPI

Job Number: 45485

Part Number: D36911

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RE-IDENTIFY AND STOCK
USING NEW B/N

ST117

JS

09/02/09

24

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/10

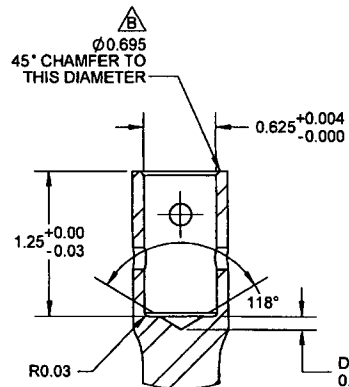
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

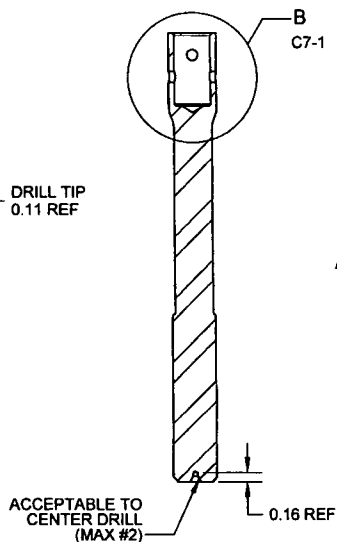


MF
09-02-09

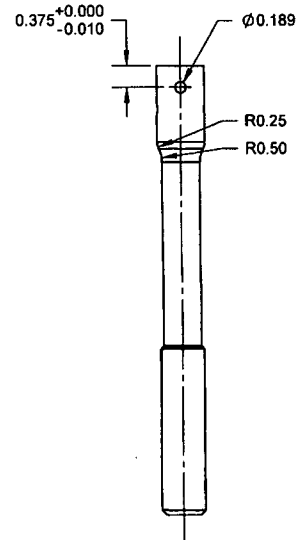
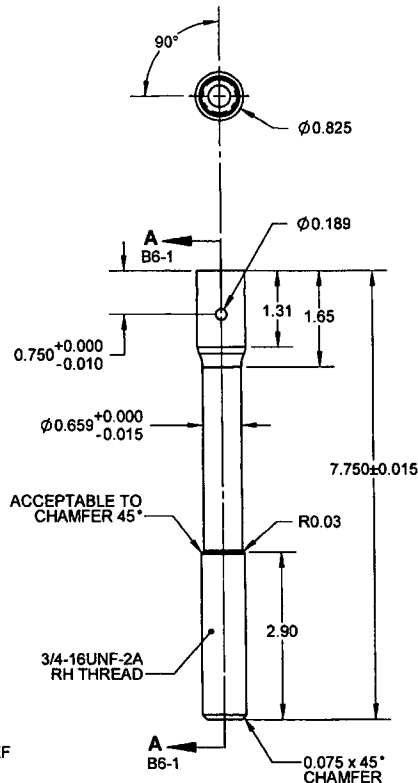
8 7 6 5 4 3 2 1



DETAIL B
SCALE 2X
C6-1



SECTION A-A
D4-1



RELEASED
08/12/15 NW

D3691-1 STUD

- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.81 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

45485

B	CHANGE TO 17-4PH H-900 (ZN A8-1); Ø0.695 WAS Ø0.665 (ZN D8-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3691	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	STUD	NTS
DATE	08.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



LIQUID PENETRANT TEST REPORT

P- 14932

CLIENT	DART AEROSPACE	DATE	FEB 5-2007	PAGE	1	OF	1		
ATTENTION	LINDA	ACUREN JOB No.	188-09-001292	TIME	AM	<input checked="" type="checkbox"/>	PM	<input type="checkbox"/>	
ADDRESS	1270 ABELDEEN ST. HAWKESBURY, ON K6H 1K7	PO/NO No.	8149	WORK LOCATION	HAWKESBURY	ACCEPTANCE STD.	ASTM 1417	REV./DATE	2007
PROJECT	F.P.I. on MACHINED PARTS								
ITEM(S) EXAMINED	54 MACHINED PARTS								

JOB DESCRIPTION	PROCEDURE No. LT-xxxx	REV./DATE	TECHNIQUE No. LT-xxxx-xxx	REV./DATE			
PART No.		MATERIAL		THICKNESS			
SCOPE	WET FLUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL						
TEST DETAILS							
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED		
FAMILY BRAND	MAGNAFLUX		BLACK LIGHT S/N 0071	<input type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc		
PENETRANT	2L 67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT	<input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER	H2O	MINIMUM DRY TIME	> 10 MIN.	OTHER			
DEVELOPER	SKD 52	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N			CAL DUE DATE FEB-09
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY				

TEST SURFACE					
SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < - 4°C/ 20°F	<input type="checkbox"/> - 4°C/ 20°F TO 10°C/ 50°F	<input type="checkbox"/> 10°C/ 50°F TO 52°C/ 125°F	<input type="checkbox"/> > 52°C/ 125°F	

RESULTS-	<input type="checkbox"/> METRIC	<input type="checkbox"/> IMPERIAL	
ITEM	COMMENTS	ACCEPT	REJECT
30 PCS - JOB# 44825		✓	
24 PCS - JOB# 45485		✓	
ALL 54 PARTS OF THESE JOB #'S HAVE BEEN 100% EXTERNAL EXAMINED AND FOUND ACCEPTABLE.			

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES		DTR # E-19809	
CLIENT REPRESENTATIVE	Jan Titley		
TECHNICIAN (SIGNATURE):	Mike Johnston	REPORT REVIEWED BY:	
NAME (PRINT):	Mike Johnston	NAME INITIALS	
CGSB LEVEL	1 ST TECHNICIAN	CGSB LEVEL	2 ND TECHNICIAN
CGSB REG. NO.	CGSB REG. NO.	CGSB REG. NO.	CGSB REG. NO.

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY